

Date: Tuesday, 10/06/2008 3:14:34 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
<b>Job Number</b>	: 39806			<b>Part Number</b>	: D2571		
<b>Estimate Number</b>	: 10530			<b>Drawing Number</b>	: D2571 REV E		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 10/06/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: E		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: MACHINED PARTS	<b>Due Date</b>	: 30/06/2008		
<b>Previous Run</b>	: 39122			<b>Qty:</b>	<i>20</i>		
<b>Written By</b>	:			<b>Um:</b>	Each		
<b>Checked &amp; Approved By</b>	: <u>JUL 08. 6. 10</u>						
<b>Comment</b>	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101007	Saddle Billet		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(\$) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No. <u>B 34875</u>		<i>ml/Jul 08/07/15</i> (13)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>39806</u> Double check by: <u>DL</u>		<i>ml/Jul 08/07/15</i> (13)
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		<i>ml/Jul 08/07/15</i> (13)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572		<i>ml/Jul 08/07/15</i> (13)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>ml/Jul 08/07/15</i> (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod / Machined +VB NCR:  No DQA:  Date: 08/07/16  
 D412-742 QA: N/C Closed:  Date: 08/07/16

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/08	2	1 part saddle lifted while machining causing vibrations on 4th axis, so dimension ② .362±.010 is .345 to .355 R.C. Tooling is starting to show wear (L.H. side)	AB 08/07/08	SCRAP PART CP Destroy and Replace B# 34875	J.L. 08/07/08 08/07/08	C 08/07/08	AB 08/07/08	C 08/07/08

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 39806

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M 12/12 08/07/15 X13

7.0 POWDER COATING POWDER COATING



M 107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:00pm

9/10 08-07-15

X13

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-F

08/07/15

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

1-8/7/16 (13)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/16 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	391804
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.446	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		.510	.501	.499	.504		
G	0.257	0.262		.259	.259	.258	.258		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.180	1.180	1.179	1.179		
K	0.558	0.578		.568	.569	.567	.568		
L	1.174	1.184		1.180	1.180	1.179	1.179		
M	1.490	1.500		1.498	1.499	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.873	3.874	3.874		
P	0.115	0.135		.124	.125	.122	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.250	.249	.248		
S	0.115	0.135		.135	.129	.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.236	.236	.240	.239		
W	0.115	0.135		.124	.120	.124	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.359	.364	.363	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631	.626	.627	.631		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.245	.250	.249		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		.126	.131	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.246	.250	.249		
AI	2.000	2.020		2.002	2.006	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>JKL / JL</i>	Audited by:	
Date:	<i>08/17/10</i>	Date:	<i>08/20/10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JKL</i>	<i>JL</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39804
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

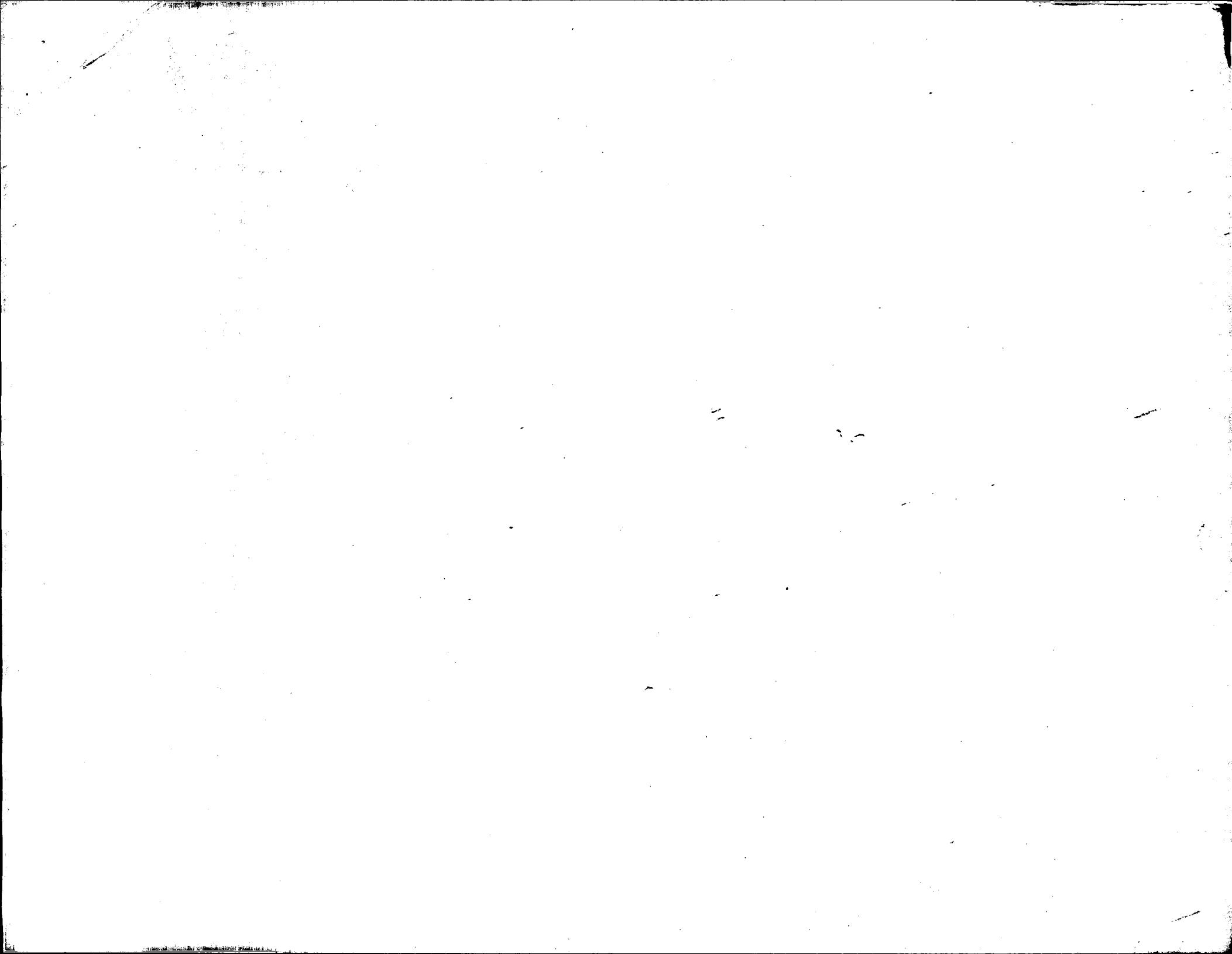
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.506	.502	.506		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.499	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.566	.566	.564	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.496	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.873	3.872	3.874		
P	0.115	0.135		.130	.129	.128	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.249	.250		
S	0.115	0.135		.130	.130	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.966	2.960	2.960		
V	0.230	0.250		.232	.232	.236	.236		
W	0.115	0.135		.124	.125	.125	.127		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.362	.363	.362	.365		
AA	0.470	0.530		.500	.506	.506	.500		
AB	0.615	0.635		.632	.630	.631	.634		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.240	.240	.244	.244		
AE	1.375	1.395		1.388	1.395	1.391	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.242	.244	.247	.246		
AI	2.000	2.020		2.000	2.006	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>DKL</i>
Date:	08/07/16

Audited by:	<i>CD</i>
Date:	08/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>SD</i>	



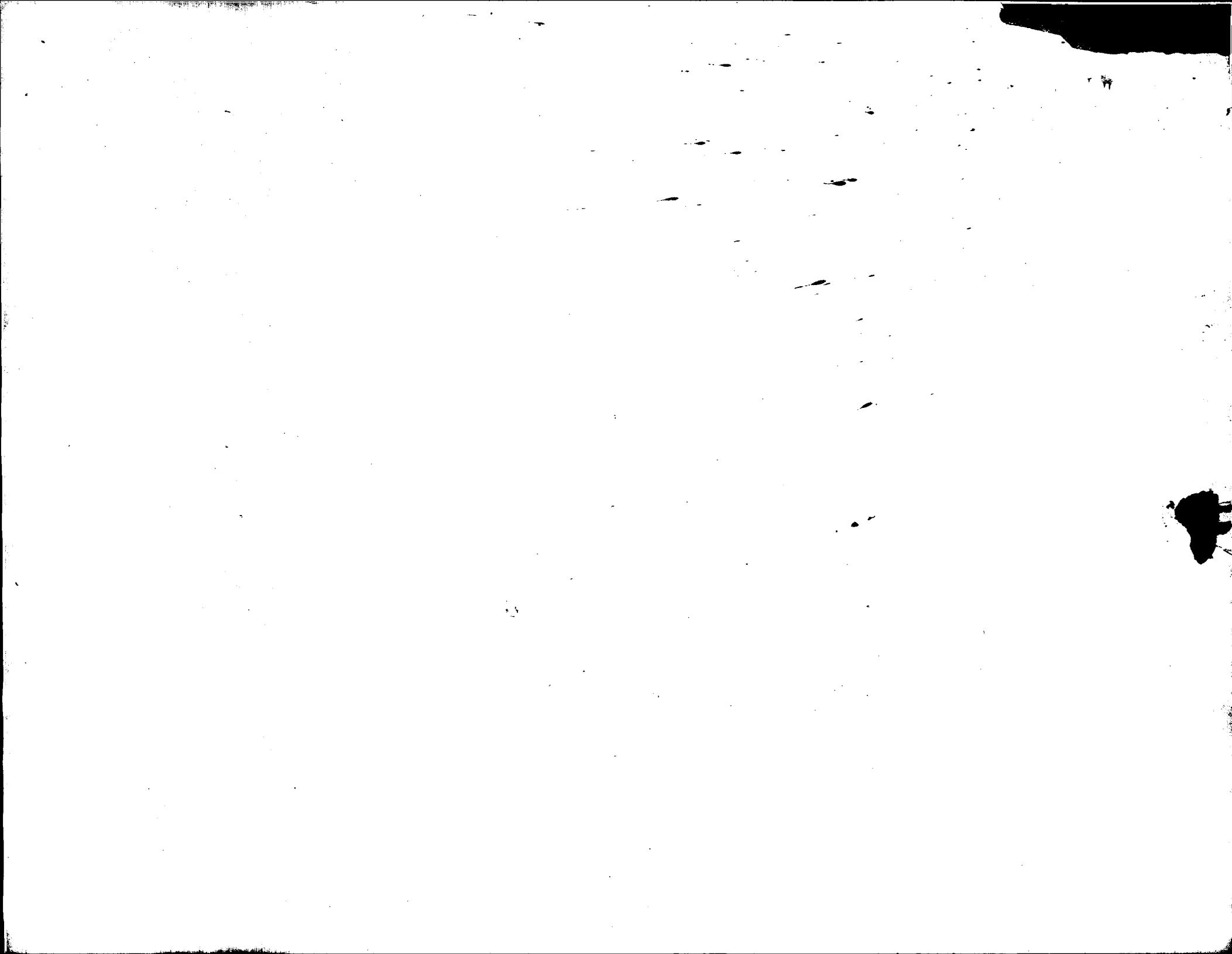
DART AEROSPACE LTD	Work Order:	39806
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

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B	1.745	1.755		1.756	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.505	.505	.504		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.499	.500	.500		
J	1.174	1.184		1.177	1.179	1.179	1.179		
K	0.558	0.578		.566	.565	.566	.568		
L	1.174	1.184		1.177	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.494	1.495	1.494		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.871	3.874	3.872	3.872		
P	0.115	0.135		.129	.129	.128	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.249	.251	.249		
S	0.115	0.135		.122	.122	.121	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.960	2.960	2.966		
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Z	0.352	0.372		.364	.364	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.634	.628	.626	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.242	.246	.247		
AE	1.375	1.395		1.390	1.390	1.388	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.245	.246	.248	.249		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>CMF</i>	Audited by:	<i>S</i>
Date:	08/07/11	Date:	08/07/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>CF</i>	<i>JLM</i>



DART AEROSPACE LTD	Work Order:	39806
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

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L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.872					
P	0.115	0.135		.130					
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T	0.178	0.198		.188					
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W	0.115	0.135		.128					
X	0.308	0.313		.309					
Y	0.760	0.765		.760					
Z	0.352	0.372		.363					
AA	0.470	0.530		.500					
AB	0.615	0.635		.628					
AC	0.053	0.073		.063		/			
AD	0.240	0.260		.243					
AE	1.375	1.395		1.391					
AF	0.115	0.135		.135					
AG	0.240	0.280		.266					
AH	0.240	0.260		.241		/			
AI	2.000	2.020		2.002		/			
AJ	0.023	0.043		.033					
Accept/Reject									

Measured by:	<i>Gnf</i>	Audited by:	<i>S</i>
Date:	08/07/15	Date:	08/07/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

